

Work Order ID 78207

78207

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January-02-12 10:14:25 AM

Item ID: D3463-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 02/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: HLJ Date: 12/01/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3463	Rev B

100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3463 using DT8875								

12-12-1 (X4)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

4/2 Ø

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

5/12/02/02

(X4)

-012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Mask areas indicated on dwg D3463 (holes, threads)								
	START TIME: <u>8:30</u>								
	OVEN TEMPERATURE: <u>4000 F</u>								
	FINISH TIME: <u>9:00</u>								
140	Wing Walk as per dwg QSI005 4.4 Batch <u>120125</u>	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

4x M / 12/02/06

4 12-2-7

4x d W 12/02/07

M119480

Dart Aerospace Ltd

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

[Handwritten signature] 12/2/07 *[Circular stamp]*

12/2/11 *[Handwritten signature]*

12-02-11 *[Handwritten signature]*

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Picklist Print

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Work Order ID: 78207

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Parent Item: D3463-042

D3463-042

Parent Item Name: Step Weldment Assembly

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV. A 05.11.18 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806 *238-806* SS DOWEL PIN 1" LONG		Purchased	No			100	Each	64.0000	2	12			
** EL 12-2-1													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ST399		64								
			117606		64		8						
D3453-3 *D3453-3* Clevis		Manufactured	No			100	Each	12.0000	1	6			
** EL 12-2-1													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA022		12								
			71900		4								
			73622		8		4						
D3453-5 *D3453-5* Plug		Manufactured	No			100	Each	11.0000	1	6			
** EL 12-2-1													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA022		11								
			59204		1								
			73623		10		3						
D3463-1 *D3463-1* Arm		Manufactured	No			100	Each	4.0000	1	6			
** EL 12-2-1													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA030		4								
			70855		4								
			75246		4								

78210x1

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Parent Item: D3463-042

D3463-042

Parent Item Name: Step Weldment Assembly

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

D3463-3 Manufactured No

100 Each 12.0000 1 6

D3463-3

Step

**

EL 12-2-1

Location

Loc Qty

Loc Code

WA023

12

46269

12

4

D3463-5 Manufactured No

100 Each 21.0000 2 12

D3463-5

End Cap

**

EL 12-2-1

Location

Loc Qty

Loc Code

WA023

21

70819

21

5

D3463-7 Manufactured No

100 Each 11.0000 1 6

D3463-7

Drag Arm

**

EL 12-2-1

Location

Loc Qty

Loc Code

WA

10

WA025

1

70857

1

73624

10

3

78202

1

1

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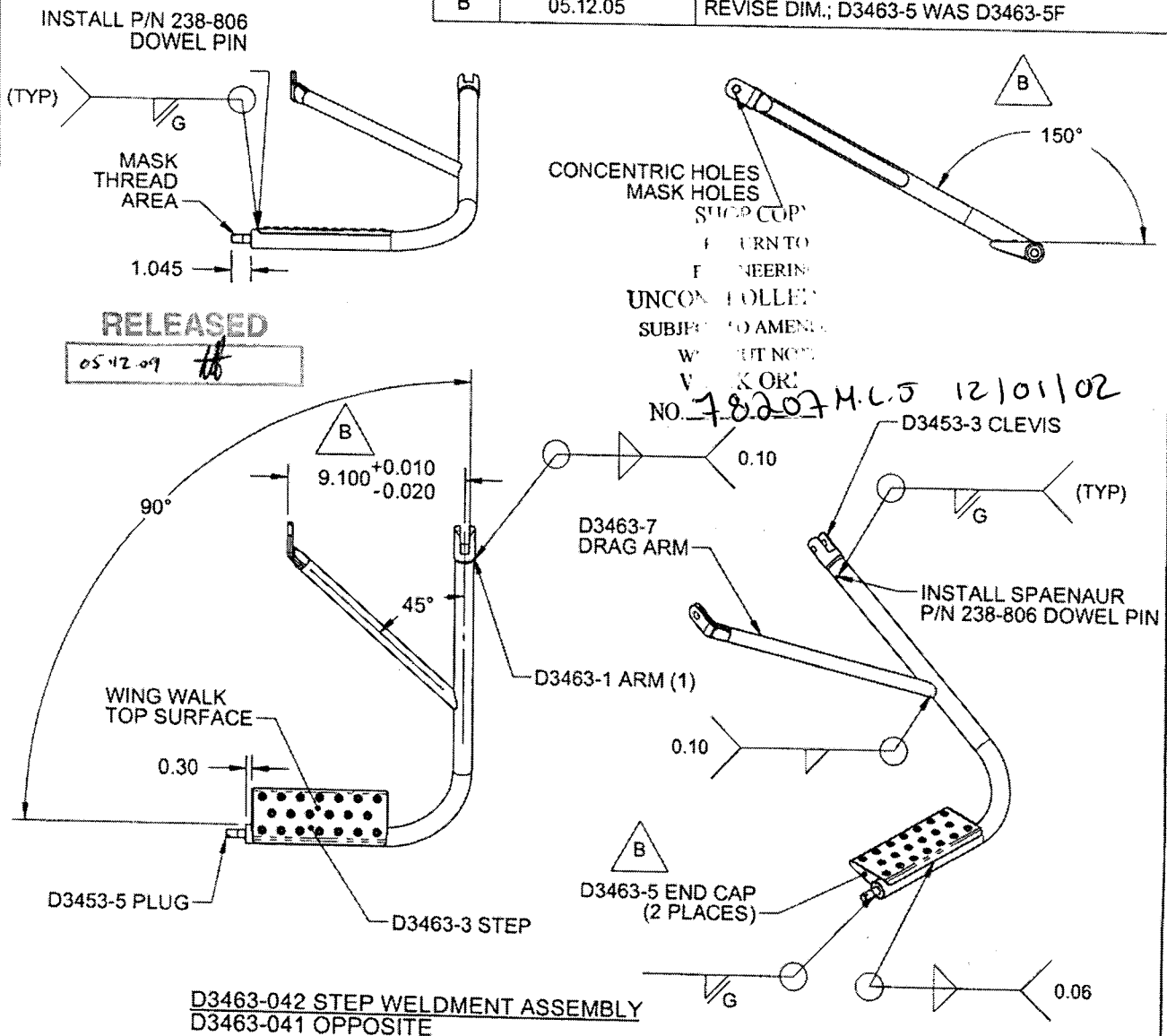
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

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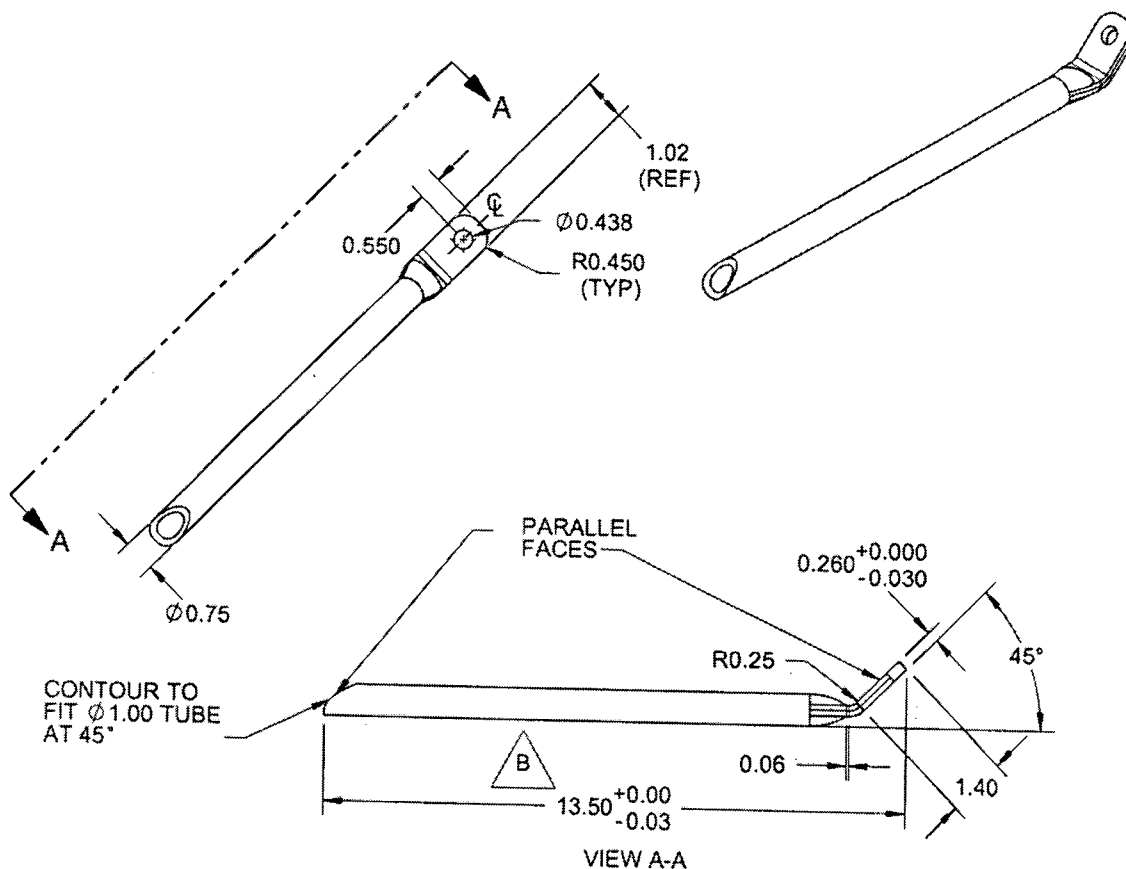
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B
DATE 05.12.05		TITLE STEP WELDMENT	SHEET 3 OF 4
			SCALE 1:4

RELEASED

05.12.05 #



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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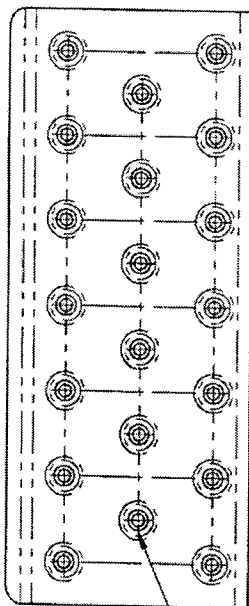
NOTE: Date & initial all entries



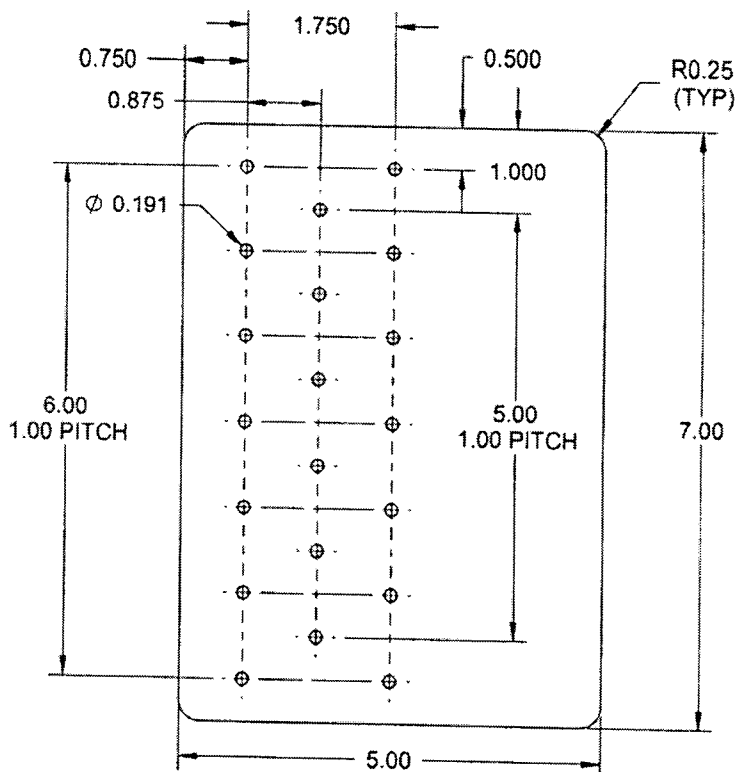
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

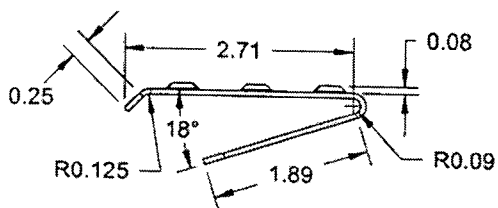
05.12.05 *[Signature]*



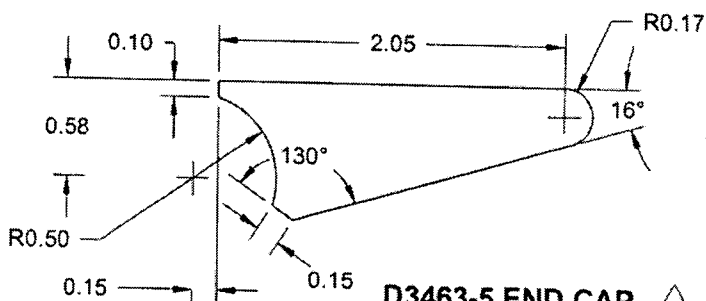
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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